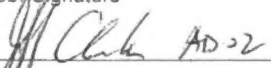
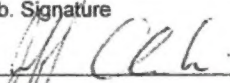


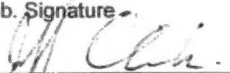
1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2013-02	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Cabin Step	80010-7475	1	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. 		
13b. Signature <i>Jeff Clarke AD02</i>		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 20 May 2014		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

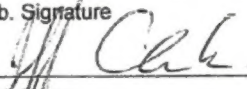
1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2013-57
6. Item	7. Description	8. Part Number	9 Qty	10. Serial/Batch No.	11. Status/Work
1.	Forward Beam Assembly	69830-02	1		
2.	Aft Beam Assembly	69831-02	1	N/A	New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
<input type="checkbox"/> Non approved design data specified in block 12.					
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 20 May 2014		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

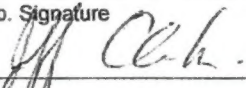
1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-15 WO2014-01 <i>QC AD02</i>	
6. Item	7. Description Cargo Basket	8. Part Number 94010-01	9. Qty. 1	10. Serial/Batch No. 94001-30	11. Status/Work New	
12. Remarks Modified with walkway on lid IAW DCL704; Black						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke AD02</i>		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 27 Jan 2014		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

LAKELSE

1. Approving Civil Aviation Authority/Country Transport Canada		AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-41	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Cargo Basket	94010-01	1	94001-31	New	
12. Remarks Modified with walkway on lid IAW DCL704						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.						
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 27 Jan 2014		14d. Name		14e. Date (dd/mmm/yyyy)
Installer Responsibilities						
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.						

1. Approving Civil Aviation Authority/Country Transport Canada		AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3				5. Work Order/Contract/Invoice WO2013-29	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	LH Aft Beam	78633-01-02	1		
2.	Forward Beam	78634-01-00	1	N/A	New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<div style="border: 1px solid black; padding: 5px;"> 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. </div>		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14c. Approved Organization Number	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 27 Jan 2014		14e. Date (dd/mmm/yyyy)	
Installer Responsibilities					
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-28	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Clamp Assembly	78620-01	4	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. 		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mm/yyyy) 27 Jan 2014		14d. Name		14e. Date (dd/mm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-04
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Short Step Assembly	82715-01	1	N/A	New
2.	Bracket	82733-01	1		
3.	Bushing	82733-02	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 27 Jan 2014		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

CARGO BASKET LID FABRICATION - COMMON

WO# 2014-01

AS350 ski 94012-01

(4) with walkway

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

Bell 429 – right or left

95912, Revision 0 – Standard Basket

Bell Medium – left or right

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

MD600

82812, Revision 0 – Standard Basket

Options

70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete

Work Order: 2014-01

AS350 SKI 94012-01 (initial or SCA #)

Date Open: 09 JAN 2014

(4) w/ WALKWAY

①

②

③

1. Rim Assembly – Basket Lid

- Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - 1 or 2 lid prop bushing holes in short tube – refer to drawing
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.

AD06

AD06

AD06

2. Weld Rim Assembly

- Record welding rod PO on attached material list.

AD-05

AD-05

AD-05

3. Inspection

- Rim for complete welds

AD01

AD01

AD01

4. Frame assembly – Lid

- General
 - Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- Insert rim from step 2 into jig.
- Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.
- Drill vent holes into rim to vent cross members into rim.
- Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

AD06

AD06

AD06

5. Frame assembly – Lid with optional walkway modification

- Fit cross members to rim in accordance with step 4.
- Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- Drill vent holes into cross members at walkway stringers.
- Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

AD06

AD06

AD06

6. Weld frame assembly.

- Record welding rod PO on attached material list.
- Jigs must remain in place for as long as practical during welding.

AD-05

AD-05

AD-05

7. Inspection

- Frame assembly for complete welds.

AD01

AD01

AD01

CARGO BASKET LID FABRICATION

① Complete
(initial or SCA #)

AD-05 AD-05 AD-05

8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid.
- Remove surface rust with scotch-brite.
- Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing.

AD-05

AD-05 AD-05

- General welding requirements for all lids:
 - Every intersection on all edges.
 - First 5 intersections along cross members, then every second intersection.
- MIG weld both short sides.
- Clamp lid over spacer at centre of lid to pre-tension mesh.
 - $\frac{3}{4}$ " for lids under 76"
 - 1" (check) for lids over 76"
- Weld remainder of mesh as indicated in a.
- Record welding rod PO on attached material list.

10. Weld lid components.

AD-05

AD-05 AD-05

- Handle brackets, locate in accordance with drawing.
 - Standard location: $\frac{1}{4}$ " outside of last cross member on both ends.
 - Record handle bracket WO and welding rod PO on attached material list.
- Lid prop bushing(s).
 - one or two in accordance with drawing.
 - Record lip prop bushing WO and welding rod PO on attached material list.
- Placard bracket. – not installed on 95912 (Bell 429)
 - Locate on cross member to set bracket in centre bay of lid.
 - Record placard bracket WO and welding rod PO on attached material list.

11. Clean up

AD-05

AD-05 AD-05

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Drill #9 through lid prop bushing(s). De-burr hole(s).
- Drill for lid bumpers using $\frac{1}{4}$ " (#3) centre drill.
 - 3 places for lids under 76"
 - 4 places for lids over 76"
- Remove surface rust with scotch-brite pad.

12. Final Inspection

To be completed by a different person than the previous steps.

AD-01

AD-01 AD-01

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).

CARGO BASKET LID FABRICATION

① Complete
(initial or SCA #)

13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

②
A006

A006

A006

Work Order: 2014-01Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Lid Fabrication

1 of 2

Date Opened: 09-Jan-2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO	
		94012	94012-01	Lid Assembly		①	③
Step 1				Rim Assembly			
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	13087	13087
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	12123	12123
Step 2				Weld Rim Assembly			
	. A/R			Welding Rod	ER70S-2 TIG Rod		
Step 3				Inspection - Rim	None		
Step 4				Frame Assembly			
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	12123	12123
Step 5		70405		Option: Frame Assembly - with walkway			
	. 10		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	14009	14009
Step 6				Weld Frame Assembly			
	. A/R			Welding Rod	ER70S-2 TIG Rod		
Step 7				Inspection - Frame Assembly	None		
Step 8				Mesh Assembly			
	. 1		--	Mesh (lid - 96" x 22")	3/4-16F Expanded Mild Steel sheet	13076	13076
Step 9				Weld Mesh			
	. A/R			Welding Rod	ER70S-6 MIG Wire		

Work Order: _____

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Lid Fabrication

2 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				<i>Weld Lid Components</i>		① ② ③
	. 1	84262	84262-01	Upper Handle Bracket Assembly		
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod	
	. A/R			Welding Rod	ER308L TIG Rod	
	. 2		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	
	. A/R			Welding Rod	ER308L TIG Rod	
	. 1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	
	. A/R			Welding Rod	ER70S-2 TIG Rod	
Step 11				<i>Clean Up</i>		
Step 12				<i>Inspection - Final Assembly</i>		
Step 13				<i>Powder Coating</i>		

CARGO BASKET ASSEMBLY - COMMON

AS350 XL
wo 2014-01

S/N 94001-30
(Black)

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

→ 94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2014-01

Date Open: _____

AD-06

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant. ✓
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid. ✓
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket. ✓
 - ii. Drill #30 through placard and bracket, using holes in placard. ✓
 - iii. Remove placard and de-burr holes in placard and on bracket. ✓
 - iv. Locate placard on bracket, and cleco in place. ✓
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets. ✓
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface. ✓
 - ii. Pull tread plate from stock. Shear tread plate to length. ✓
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder. ✓
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot. ✓
 - v. Mark and drill #30 holes: ✓
 1. 0.25" from edge of tread plate, centre on cross members (0.38") ✓
 2. 0.25" from edge of tread plate, middle of each walkway stringer ✓
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides. ✓
 - vii. De-burr holes in lid tubes. ✓
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate. ✓
 - ix. Set tread plate in place, secure with clecos if necessary. ✓
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

AD-06

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

10 FT LBS

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

A006

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

ADOC

- a. Install handle brackets.
 - i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
 - ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
 - iii. Torque AN3 bolts to ??.
- b. Install handle
 - i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
 - ii. Grease two 36275-01 bushings with ?? . Insert into bushings of handle assembly.
 - iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
 - iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
 - v. At first end, remove bolt and repeat step iv.
 - vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
 - vii. Torque AN3 bolts to ??.
- c. Check handle
 - i. Operate handle to ensure handle does not bind and springs hold handle in.
 - ii. Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

ADOC

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

2006

6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2014-01

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Assembly

1 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		94010-01	Cargo Basket Assembly	S/N 94001-30	(BLACK)
Step 1				<i>Lid Assembly</i>		
	1		94012-01	Basket Lid Assembly		
Step 1.a.	4		49205-14	Bumper	Argus Industries Bumper	11010
	A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	1		94027-01	Placard	0.063 Sheet, 6061-T6 Aluminum	13048
	4		CR3213-4-02	Cherry Rivet		13048
Step 1.c.	1		70405-01	Lid Step Modification		
(option)	1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	13048 78401-27
	A/R		CR3213-4-02	Cherry Rivet		13048
	A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	1		94011-01	Basket Body Assembly		* 2014-01
	4		96710-01	Fitting	Alternate: Ancra 40088-14	13048
	8		AN960-616	Washer		13048
Step 3				<i>Hinge Installation</i>		
	1		MS20001P4	Piano Hinge	95"	13061
	8		CR3523-5-02	Cherry Rivet		13048
	A/R		CR3213-5-02	Cherry Rivet		13048
Step 4	1		84255-01	<i>Handle Installation</i>		
Step 4.a.	2		84267-01	Bracket	Delrin, 3/4" Sheet	8426701
	4		AN3-11A	Bolt		1400
	8		NAS1149F0363P	Washer		13084
	4		MS21044N3	Nut		13048

Work Order: _____

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Assembly

2 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	1		84261-01	Handle Assembly		2013-54
	2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	12083
	2		36275-01	Bushing	Brass, 5/16" Dia	2013-33
	2		AN3-12A	Bolt		14001
	4		NAS1149F0363P	Washer		13084
	2		MS21044N3	Nut		13048
Step 5				Lid Brace Installation		
	1		36280-01	Brace Assembly		36280-02 with 2013-01
	1		AN3-15A	Bolt		13017
	1		AN3-17A	Bolt		13017
	2		AN970-3	Washer		13084
	3		NAS1149F0363P	Washer		13084
	2		MS21044N3	Nut		13048
Step 6				Inspection	None	

CARGO BASKET HOOP FABRICATION - 94023

General

These instructions apply to cargo basket attachment hoop 94023-01. Refer to the following drawings, at the current revision, for dimensions and details:

94023, Revision 0 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

Work Order: 2014-01

Complete
(initial or SCA #)

Date Open: 09 JAN 2014

1. ½ Hoop Fabrication – ½" hoop

- a. Cut ½" x 0.035 material to 23.0", square ends. ✓
- b. Record material PO on attached material list. ✓
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander. *Buffing wheel* ✓
- d. Remove writing on tubes with acetone and scotch bright. ✓
- e. On the hoop bending fixture, set the following stops:
 - i. Upper tube stop: ?? *20 3/4 in.*
 - ii. Lower bend stop: 12mm
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop. ✓
- g. Slide shim all the way forward on bender to secure tube in die ✓
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure. ✓
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required. ✓
- j. Check for:
 - i. hoop height: 18" (Outside to outside)
 - ii. adjust upper stop for height if required ✓

ADa

2. ½ Hoop Machining – ½" hoop – Handle Provisions 84262-01

- a. Start with ½" half hoop from step 1. ✓
- b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop). ✓
- c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
 - i. locate 0.23" from edge (within tolerance specified on drawing).
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder. ✓
- e. Tag in process hoop(s) and place into stock. ✓

AD01

ADOL

3. ~~3.~~ Never mind.
1/2 Hoop Fabrication – 1" hoop

33 5/8" one end 60° and

- Cut 1" x 0.065 material to 30.0", on end square, one end @ 16 degrees. ✓
- Record material PO on attached material list. ✓
- De-burr cut ends using a sanding disc on a die-grinder or disc sander. ✓
- Remove writing on tubes with acetone and scotch bright.
- On the hoop bending fixture, set the following stops:
 - Upper tube stop: ?? 21 9/16" ✓
 - Lower bend stop: ?? 2 1/2" washer ✓
- Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop. ✓
- Slide shim all the way forward on bender to secure tube in die to tool rest ✓
- Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure. ✓
- Check tube bend for angle using hoop jig. Adjust stops if required. ✓
- Check for:
 - hoop height from jig
 - adjust upper stop for height if required
 - length to allow 60 degree cut.
- Using hoop jig, mark for 60 degree cut on bottom end. Cut to length. ✓
- De-burr cut end using a sanding disc on a die-grinder or disc sander. ✓

4. 1/2 Hoop Machining – 1" hoop

ADOL

- Start with 1" 1/2 hoop as stock. ✓
- Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.75" and set X 0. Shift Y -0.5". Set stop against end of tube.
- Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling. ✓
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Set tube in vise with 60 degree end on right.
- Using 1/2" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling. ✓
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder. ✓
- Tag in process hoop(s) and place into stock. ✓

ADOL

5. Joint Preparation

ADOL

- Set 1" hoop in hoop jig. Insert 1/2" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto 1/2" hoop. Trim 1/2" hoop with vertical bandsaw if required, and shape to match slot with disc sander.
- Insert one 94023-05 lug (flat end) at top and 94023-07 lug (angled end) at bottom into holes in 1" hoop. Seat top lug flush with inboard face of tube using a C-clamp or vise. Attach 16 7/8" spacing jig with 3/8-24 bolts to lugs and space jig 7/8" out from hoop. Mark 94023-07 lug and trim or grind to fit.

AD-05

6. Welding – Lugs

- ✓a. Insert one 94023-07 lug (flat end) at top and 94023-05 lug (angled end) at bottom into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 16 7/8" spacing jig with 3/8-24 bolts to lugs and space jig 7/8" out from hoop.
- ✓b. TIG weld all around both sides of lugs. 2 places. Grind angled lug into radius of hoop before welding.
- ✓c. Record lug and welding rod PO/WO on attached material list.

7. Welding – Handle Bushings – 84262-01

AD-05

- ✓a. Insert 84271-01 bushings into ½" hoop prepared in step 2. above. (40)
- ✓b. TIG weld bushing both sides, 2 bushings per hoop.
- ✓c. Record bushing and welding rod PO/WO on attached material list.

8. Welding – Hoop Assembly

AD-05

- ✓a. Insert 1" hoop from step 6 and ½" hoop from step 7 into hoop jig. Seat ½" hoop into slot in 1" hoop.
- ✓b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- ✓c. TIG weld around ½" hoop in slot.
- ✓d. Cap ½" – 1" tube joint with 76423-04 cap. TIG weld around cap.
- ✓e. Record cap and welding rod PO/WO on attached material list.

9. Finishing and Inspection

AD-01

- a. Run 3/8-24 tap through welded lugs.
- b. Grind inside surfaces flush at lugs and slot in 1" tube.
- c. Inspect hoop for conformity to drawing.
- d. Tag complete and inspected hoop(s) and place into stock.

Work Order: 2014-01Date Opened: 09 JAN 2014

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Hoops Fabrication

1 of 1

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/NO
			94030-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	12123
			94023-01	Hoop - attachment		
Step 1				1/2 Hoop Fabrication - 1/2" hoop		
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	12123
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	. 1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	13023
Step 4				Machining	None	5/8" holes / 2 ea 1/2" slot 2" long
Step 5				Joint Preparation	None	
				Welding		
Step 6	. 1		94023-05	Stud	1018 Mild Steel, 5/8" Dia.	13005/2013-24
	. 1		94023-07	Stud	1018 Mild Steel, 5/8" Dia.	13005/2013-24
Step 7	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	11049
Step 8	. 1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	PO# 9010 / 12131
	A/R		--	Welding Rod	ER70S-2	PO# 14005
Step 9				Finishing and Inspection	None	

CARGO BASKET ASSEMBLY - COMMON

AS350 XL SKI

General

WD 2014-01

S/N 94001-72

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

→ 94010, Revision 0 – Extra Large (ski) Basket *OK*

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2014-01

Date Open: _____

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant. ✓
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid. ✓
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket. ✓
 - ii. Drill #30 through placard and bracket, using holes in placard. ✓
 - iii. Remove placard and de-burr holes in placard and on bracket. ✓
 - iv. Locate placard on bracket, and cleco in place. ✓
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets. ✓
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface. ✓
 - ii. Pull tread plate from stock. Shear tread plate to length. ✓
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder. ✓
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot. ✓
 - v. Mark and drill #30 holes:
 - 1. 0.25" from edge of tread plate, centre on cross members (0.38") ✓
 - 2. 0.25" from edge of tread plate, middle of each walkway stringer ✓
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides. ✓
 - vii. De-burr holes in lid tubes. ✓
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate. ✓
 - ix. Set tread plate in place, secure with clecos if necessary. ✓
 - x. Rivet placard with CR3213-4-02 CherryMax rivets ✓
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink. ✓
 - ii. Run 3/8-24 tap into attachment lugs to clear threads. ✓
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14) ✓
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket. ✓
 - 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only. ✓
 - b. Install 3 96710-01 fittings in remaining locations. ✓
 - v. Torque to ??

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ?? *N/A 49350 ski basket dk*
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list. *dk*

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"*dk*
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets) *N/A wide basket dk*
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets) *dk*
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos. *dk*
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos. *dk*
 - v. Remove hinge and de-burr holes in hinge and basket rim. *dk*
 - vi. Cleco hinge to basket with 5/32 clecos. *dk*
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end *dk*
 - 2. CR3213-5-02 aluminum rivets – all other locations *dk*
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets) *dk*
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos. *dk*
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos. *dk*
 - iv. Remove hinge and de-burr holes in hinge and lid rim. *dk*
 - v. Cleco lid to hinge with 5/32 clecos. *dk*
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end *dk*
 - 2. CR3213-5-02 aluminum rivets – all other locations *dk*

- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. ^{Lube} Grease two 36275-01 bushings with ^{add oil 28 Grease} ?? Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

6. Final Inspection

Dual inspection by a different person than assembled the basket.

a. Check for general condition and correct assembly:

- i. Bolts are tight
- ii. Rivets are installed correctly
- iii. Handle operates correctly
- iv. Lid brace operates correctly

b. Check that PO/WO numbers have been recorded.

Dual

i have conducted an inspection
for conformance to the applicable
technical information.

Sign off.

The described product has
been manufactured in accordance
with the applicable supplemental
type certification requirements

Work Order: 2014-01

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Assembly

1 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		94010-01	Cargo Basket Assembly	<i>slw 94001-32</i>	
Step 1				<i>Lid Assembly</i>		
	. 1		94012-01	Basket Lid Assembly		
Step 1.a.	. . 4		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		94027-01	Placard	0.063 Sheet, 6061-T6 Aluminum	
	. . 4		CR3213-4-02	Cherry Rivet		
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	
	. . A/R		CR3213-4-02	Cherry Rivet		
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		94011-01	Basket Body Assembly		
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	
	. . 8		AN960-616	Washer		
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	95"	
	. 8		CR3523-5-02	Cherry Rivet		
	. A/R		CR3213-5-02	Cherry Rivet		
Step 4	. 1		84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	
	. . 4		AN3-11A	Bolt		
	. . 8		NAS1149F0363P	Washer		
	. . 4		MS21044N3	Nut		


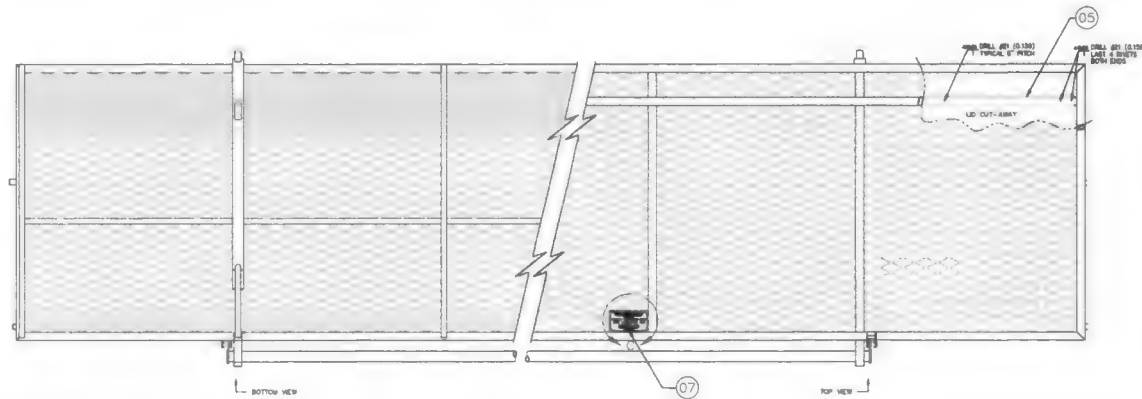
Work Order: _____

Date Opened: _____

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Assembly

2 of 2

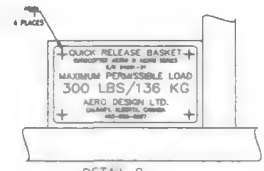
Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	1		84261-01	Handle Assembly		
	2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	2		36275-01	Bushing	Brass, 5/16" Dia	
	2		AN3-12A	Bolt		
	4		NAS1149F0363P	Washer		
	2		MS21044N3	Nut		
Step 5				<i>Lid Brace Installation</i>		
	1		36280-01	Brace Assembly		
	1		AN3-15A	Bolt		
	1		AN3-17A	Bolt		
	2		AN970-3	Washer		
	3		NAS1149F0363P	Washer		
	2		MS21044N3	Nut		
Step 6				<i>Inspection</i>	<i>None</i>	



0000-14 (TYP)
0000-04 (TYP) (S/R)

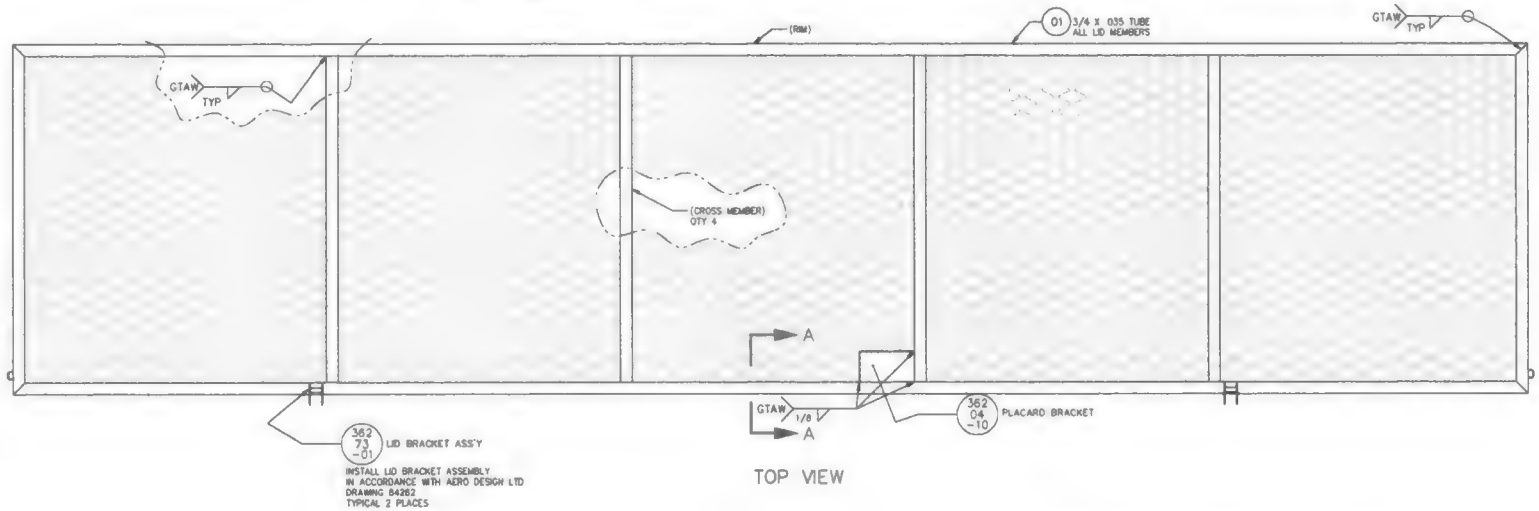
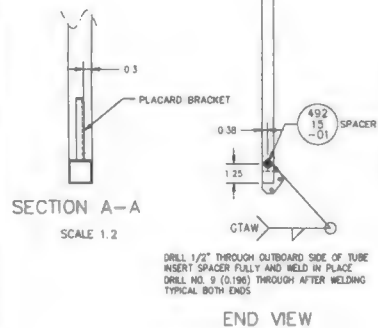
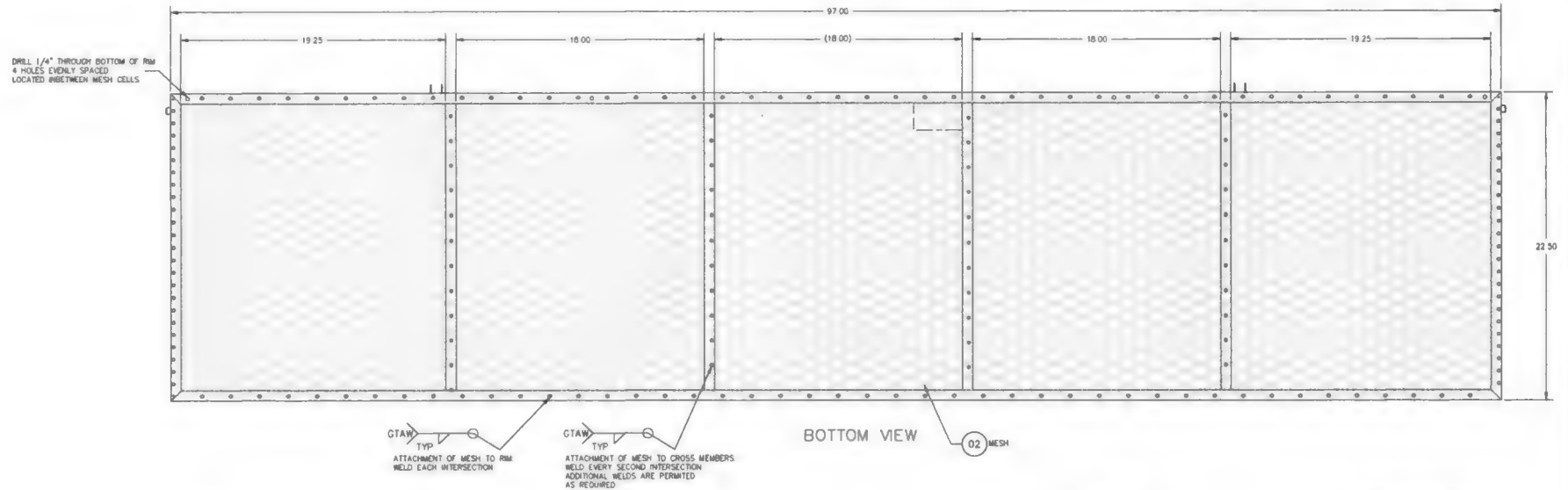
DETAIL B

SCALE 1/2
TYPICAL FRONT AND REAR



1	MISCELLANEOUS	BILL LADDERS					
2	400-7-2	WASHER					
3	WASHER/DRUM/SPRAYER	WASHER					
4	400-17-1	WASHER					
5	400-17-1	WASHER					
6	400-17-1	WASHER					
7	400-17-1	WASHER					
8	400-17-1	WASHER					
9	400-17-1	WASHER					
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62	400-17-1	WASHER					
63	400-17-1	WASHER					
64	400-17-1	WASHER					
65	400-17-1	WASHER					

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



NOTES

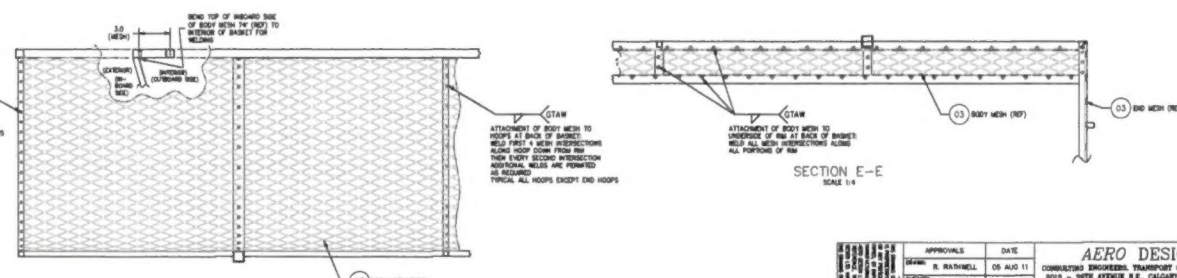
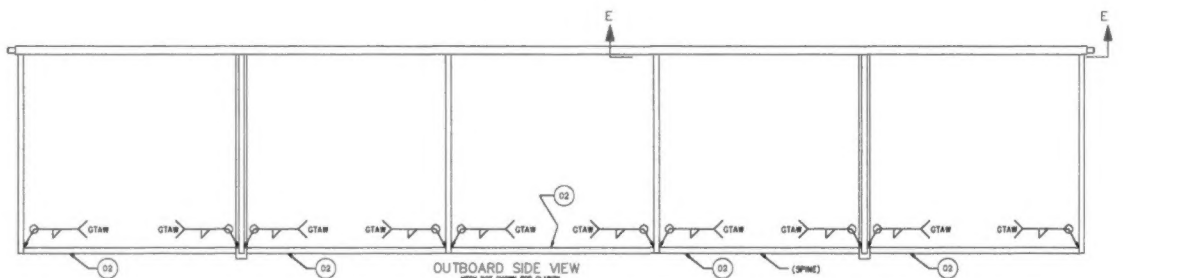
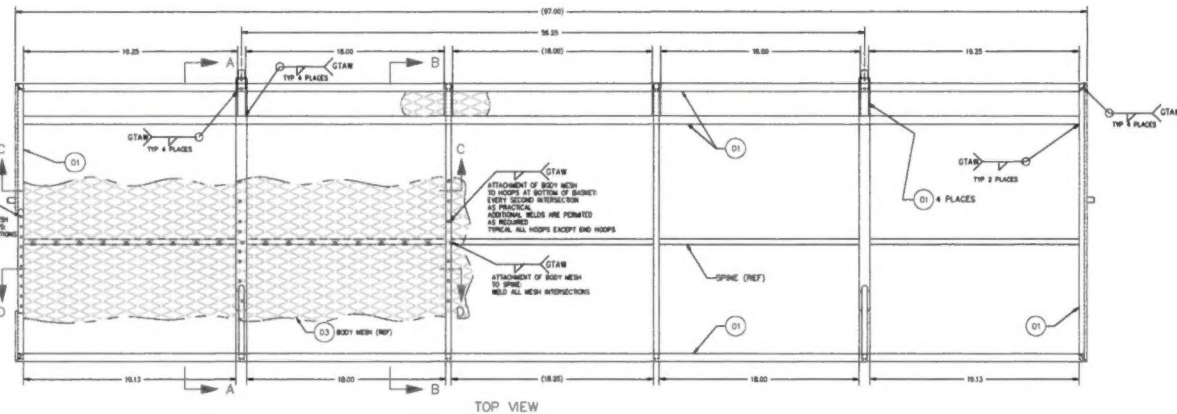
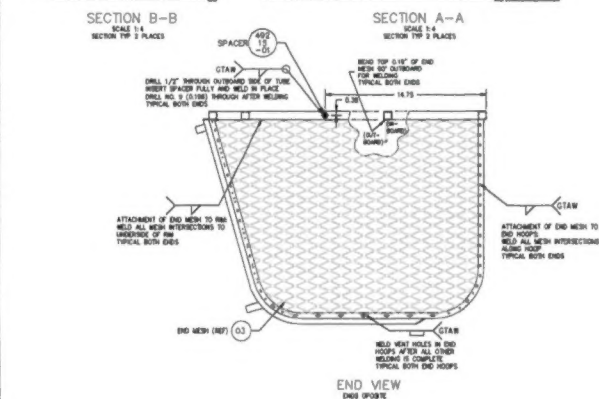
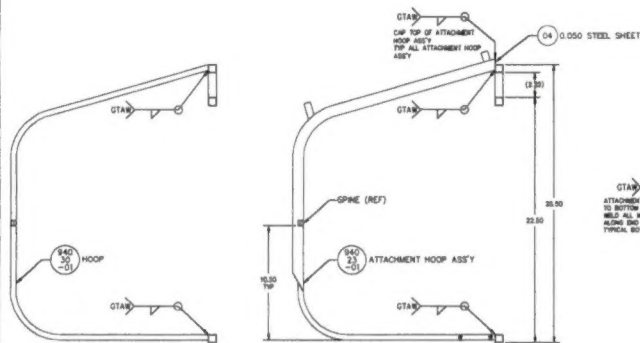
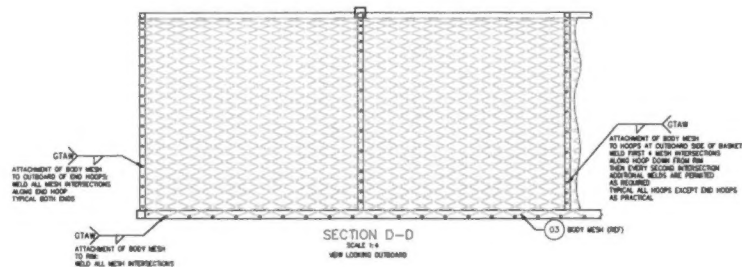
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. PRIOR TO WELDING, DRILL 1/16" VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
4. FINISH: THOROUGHLY CLEAN AND POWDER COAT LID WELDED ASSEMBLY.

PART NO	ITEM	DESCRIPTION	MATERIAL/NOTE	MATERIAL SPEC	STOCK SIZE
1	36204-10	PLACARD BRACKET			
2	36273-01	LID BRACKET ASS'Y			
2	49216-01	SPACER			
A/R	3/4 - 16F	02 MESH	STEEL	STEEL	
A/R	04012-01	01 SQUARE TUBE	4130 STEEL COND. N	ML-T-6736	0.75 x 0.035 SQR TUBE
QTY					

LIST OF MATERIALS

<div>1. REMOVE ALL BURRS AND BREAK SHARP EDGES 2. PRIOR TO WELDING, DRILL 1/16" VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD. 3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT. 4. FINISH: THOROUGHLY CLEAN AND POWDER COAT LID WELDED ASSEMBLY.</div>	APPROVALS		DATE	<div>AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 280M 2013 - 39TH AVENUE N.E. CALGARY, ALBERTA, CANADA, T2E 6R7 Tel: (403) 250-0887 Fax: (403) 250-0888 www.aerodesign.ca</div>	<div>SCALE 1:4 SHEET 1 OF 1</div>	DWG. NO.	DWG. NO.	REV
	DRAWN: R RATHWELL		05 AUG 11					
	CHECKED: E BURDON							
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON							
	DECIMALS	ANGLES						
	XXX ±0.010	±1/2°						
	XX ±0.03							
	X ±0.1							
						A1	94012	0

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0			



- NOTES
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
 2. PRIOR TO WELDING, DRILL 1/8" VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES.
 3. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS B5.9C.
 5. WELDING AND SHALL CONFORM TO EXPOS-1 OR EQUIVALENT.
 6. FINISH THOROUGHLY CLEAN AND POWDER COAT BASKET WELDED ASSEMBLY.

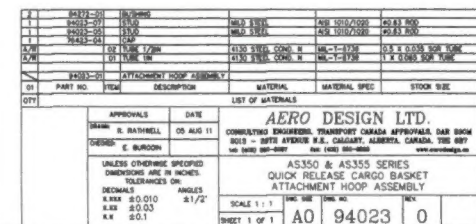
P/N	QTY	ITEM	DESCRIPTION	MATERIAL/NOTE	MATERIAL SPEC	STOCK SIZE
4130	1	STEEL SHEET	STEEL SHEET	STEEL	STEEL	STEEL THICKNESS 0.060
4130	1	STEEL SHEET	STEEL SHEET	STEEL	STEEL	STEEL THICKNESS 0.060
4130	1	STEEL SHEET	STEEL SHEET	STEEL	STEEL	STEEL THICKNESS 0.060
4130	1	STEEL SHEET	STEEL SHEET	STEEL	STEEL	STEEL THICKNESS 0.060
4130	1	STEEL SHEET	STEEL SHEET	STEEL	STEEL	STEEL THICKNESS 0.060
4130	1	STEEL SHEET	STEEL SHEET	STEEL	STEEL	STEEL THICKNESS 0.060
4130	1	STEEL SHEET	STEEL SHEET	STEEL	STEEL	STEEL THICKNESS 0.060
4130	1	STEEL SHEET	STEEL SHEET	STEEL	STEEL	STEEL THICKNESS 0.060
4130	1	STEEL SHEET	STEEL SHEET	STEEL	STEEL	STEEL THICKNESS 0.060
4130	1	STEEL SHEET	STEEL SHEET	STEEL	STEEL	STEEL THICKNESS 0.060

APPROVALS	DATE	REVISIONS	DATE
DESIGNED BY: E. BURROUGHS	05 AUG 11	1	05 AUG 11
CHECKED BY: E. BURROUGHS	05 AUG 11	2	05 AUG 11
APPROVED BY: E. BURROUGHS	05 AUG 11	3	05 AUG 11
DATE: 05 AUG 11			
SCALE: 1:4			
SHEET: 1 OF 1			

AERO DESIGN LTD.
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAB BROW
3000 - 10TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6E4
TEL: (403) 242-8888 FAX: (403) 242-8888
WWW.AERODESIGN.LTD.CA

AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
BASKET ASSEMBLY

SCALE: 1:4
SHEET: 1 OF 1
A0 94011 0



REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.125 HIGH
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH
"S/N 94001-XX" - 0.080 HIGH
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
"300 LBS/136 KG" - 0.200 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"CALGARY, ALBERTA, CANADA" - 0.080 HIGH
"403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)
4 PLACES



01 PLACARD

94027-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

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	DRAWN: R. RATHWELL		OCT 3, 2011					
	CHECKED: E. BURGAIN							
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				EUROCOPTER AS350 & AS355 SERIES LARGE QUICK RELEASE CARGO BASKET PLACARD			
SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.		
SHEET 1 OF 1		A1		94027		0		



WO# 2014-01

See Build Sheets